

Date: Monday, 4/10/2006 11:14:43 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER RING
Job Number : 26619	
Estimate Number : 12176	
P.O. Number : N/A	Part Number : D34765
This Issue : 4/10/2006 S.O. No. : N/A	Drawing Number : D3476 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 26281	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 4/28/2006
Checked & Approved By : <u>06.04.10</u>	Qty: 10 Um: Each
Comment : Est Rev: A New Issue 06-02-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 1042
E-mail or Ship DXF file to vendor
Laser cut flat pattern as per Dwg D3476
Possible supplier: Ind. Laser
Material release note is required.

06/04/28

2.0	D34765F	SPACER RING, FLAT PATTERN
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
FLANGE PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

06/04/28

(10)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06.05.02

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.
2-Roll as per Dwg D3476

06/05/19

06/05/03 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LP Date: 06/06/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:14:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER RING

Job Number: 26619

Part Number: D34765

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



2060523

Comment: INSPECT WORK TO CURRENT STEP

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub Contracting OUTSIDE SERVICES

Issue P/O:

Electro Chemically Polish weldment as per Dwg D3476

Ensure Certificate of Conformity is attached

N/A

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

06/06/01

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 442

06/06/01 10

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

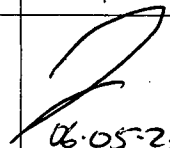
06/06/02 10

Job Completion



06/06/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-23	7 8	No electro polish req'd. remove step. Add polish with blue pad.				W	 06-05-23

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

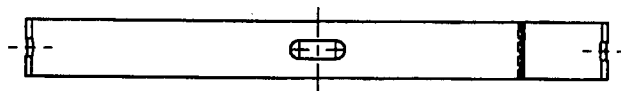
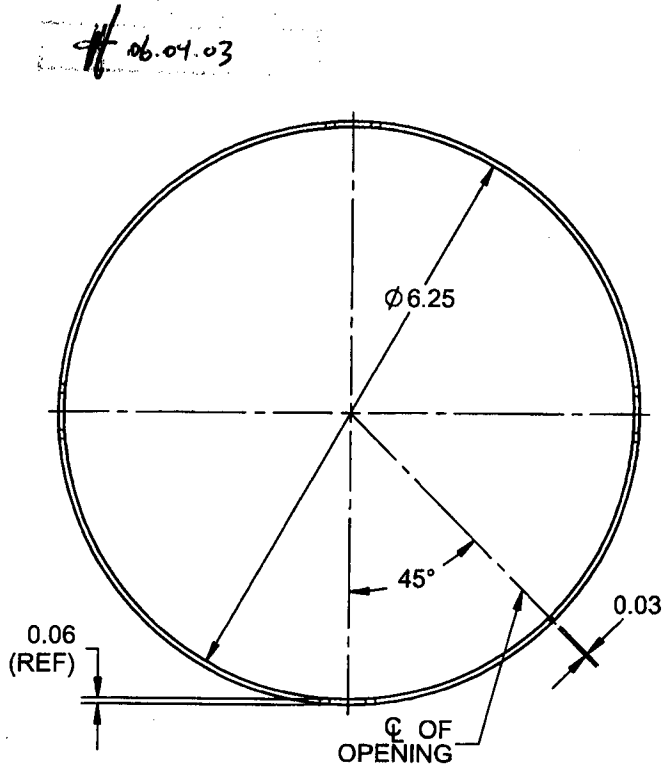
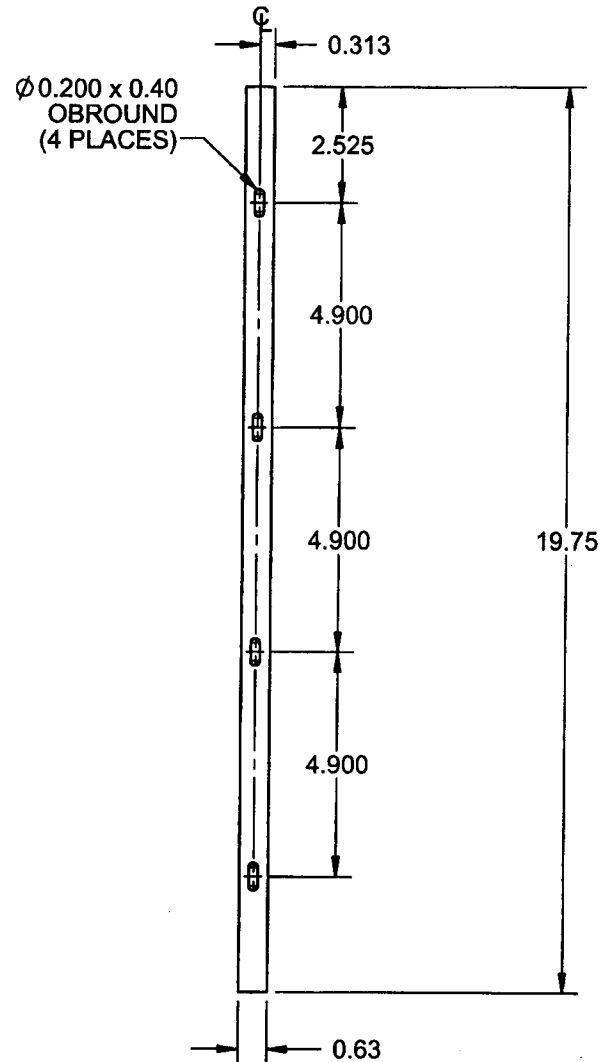
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3476	REV. A SHEET 6 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

**D3476-5 SPACER-RING****D3476-5F SPACER-RING**
FLAT PATTERN**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED), 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26619

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F51219PC002

METALLURGICAL TEST REPORT

 NORTH AMERICAN STAINLESS CANADA, INC.
 740 IMPERIAL ROAD NORTH
 GUELPH, ON N1E 1Z3

NORTH AMERICAN STAINLESS CANADA, INC.

Certificate: 6511 3

Mail To:

 WILKINSON STEEL AND METALS
 888 SOUTHEAST DRIVE
 VANCOUVER, BC V5X2V3

Ship To:

 WILKINSON STEEL AND METALS
 888 SOUTHEAST DRIVE
 VANCOUVER, BC V5X2V3

Date: 3/14/2006

Page: 1

Customer: 007115 001

Steel: 304

Finish: 2B

Your Order: F51219PC002

NAS Order: IN 0006074 01

Corrosion: ASTM A262/02a, 1608end-OK

PRODUCT DESCRIPTION:

 STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
 ASTM A240/05a, 480/05, 666/05, ASME SA240/04-A05, 480/04-A05, SA666/04
 Q06766D-A X NO PPM, AMS 5513H X MARKER PIN, MIL 5059D, AND 3, X CROWN MEAS

REMARKS:

 Material free from mercury contamination. No weld repairs.
 EN 10204 3.1 PED 97/23/EC Annex 1, Para. 4.3 Q06766D Cond A
 Material is RoHS-Compliant

Product Id	Coil #	Thickness	Width	Weight	Length	Mark	Piscom	Commodity Code
B44828	B44828	.0173	48.0000	2,460 SHEETS	096.00	2	108	

CHEMICAL ANALYSIS

Heat	CH	C	CR	CU	MN	MO	N	NI	P	S	SI
89T1	US	.046	18.306	.391	1.671	.337	.052	8.161	.029	.001	.235

MECHANICAL PROPERTIES

Product Id#	Coil #	Id Coil	UTS KSI	.2% YS KSI	ELONG %-2"	Tail Hard	Hard R45T
B44828	0489T1	F T	102.19	54.50	57.72	54.00	55.50

QC ENGINEER

3/14/2006

 SP
 06/04/28

03/23/2006 03:26

15023476424

105

PAGE 00014

MATERIAL TEST/INSPECTION CERTIFICATE



YIEH MAU CORP.

INVOICE NO. : F05MB11

COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION : AISI 304

CUSTOMER : INTEGRIS METALS LTD.

工廠:高雄縣路竹鄉廣安路345號
345, SHUN AN RD. LU CHU HSLANG
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)6972385 FAX:(07)6973006
CERTIFICATE NO. F05MB11
DATE OF ISSUE:1230/2005
PAGE:2/3

90270957

ITEM NO.	SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties					Chemical Composition								
			Tensile Test				GL=50 mm				(%)									
			Y.S. (N/mm ²)	T.S. (N/mm ²)															EL. (%)	HRB
							C	Si	Mn	P	S	Ni	Cr	N						
							x100	x100	x100	x1000	x100	x100	x100	x100						
AISI 304, NO.4 (SI) FINISH, WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK-PASS, SLITTED EDGE.																				
7426-3530	18GA\48"X144"	1	1,435	3,164	YU139523	4BS18584-12	296	655	53	83	164	4.6	51	99	33	8	805	1856	2.2	
7426-3539	18GA\60"X120"	1	1,424	3,139	YU137544	4BS18469A-11	308	701	50	83	165	4.7	50	117	31	5	804	1815	3	
7426-8159	16GA\48"X 96"	1	1,445	3,186	YU129710	4BS18607-14	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2	
7426-6159	16GA\48"X 96"	1	1,445	3,186	YU139710	4BS18697-15	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2	
7426-6159	16GA\48"X 96"	1	1,445	3,186	YU139710	4BS18697-16	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2	
7426-6288	16GA\48"X120"	1	1,462	3,223	YU139710	4BS18697-17	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2	
7426-6288	16GA\48"X120"	1	1,462	3,223	YU139710	4BS18697-18	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2	
7426-6288	16GA\48"X120"	1	1,464	3,225	YU139710	4BS18697-19	297	639	52	84	168	3.6	49	110	34	3	812	1818	3.2	
7426-6343	16GA\60"X 96"	1	1,440	3,175	YU140033	4BS18975B-11	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7	
7426-6353	16GA\60"X120"	1	1,418	3,126	YU140033	4BS18975B-16	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7	
7426-6353	16GA\60"X120"	1	1,195	2,635	YU140033	4BS18975B-17	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7	
7426-6363	16GA\60"X144"	1	1,375	3,031	YU140033	4BS18975B-13	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7	
7426-6363	16GA\60"X144"	1	1,374	3,029	YU140033	4BS18975B-13	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7	
7426-9049	14GA\48"X120"	1	1,426	3,144	YU140207	4BS20605A-11	314	704	49	86	175	5.5	51	125	35	9	808	1818	1.8	
7426-9049	14GA\48"X120"	1	1,421	3,133	YU140207	4BS20605A-12	314	704	49	86	175	5.5	51	125	35	9	808	1818	1.8	
7426-9049	14GA\48"X120"	1	1,421	3,133	YU140207	4BS20605A-13	314	704	49	86	175	5.5	51	125	35	9	808	1818	1.8	
7426-9265	14GA\60"X120"	1	1,442	3,179	YU140018	4BS19451A-11	306	672	50	85	173	4.9	47	118	32	10	804	1830	2.8	
7427-4844	12GA\48"X120"	1	1,362	3,003	YU235779	4BS18646A-113	308	641	53	84	166	4.6	48	118	35	4	814	1823	3.4	
7427-4844	12GA\48"X120"	1	1,362	3,003	YU235779	4BS18646A-114	308	641	53	84	166	4.6	48	118	35	4	814	1823	3.4	
7427-7166	11GA\48"X 96"	1	1,473	3,247	YU140191	4BS20468A-113	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1	
7427-7166	11GA\48"X 96"	1	1,473	3,247	YU140191	4BS20468A-114	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1	
7427-7177	11GA\48"X120"	1	1,308	2,884	YU236346	4BS20446B-113	293	655	51	83	162	4.1	49	124	33	7	810	1817	3	
7427-7177	11GA\48"X120"	1	1,313	2,895	YU236346	4BS20446B-115	293	655	51	83	162	4.1	49	124	33	7	810	1817	3	
7427-7177	11GA\48"X120"	1	1,312	2,892	YU236346	4BS20446B-116	293	655	51	83	162	4.1	49	124	33	7	810	1817	3	
7427-7177	11GA\48"X120"	1	1,316	2,901	YU140191	4BS20468B-211	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1	
7427-7177	11GA\48"X120"	1	1,316	2,901	YU140191	4BS20468B-212	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1	
7426-3420	18GA\36"X144"	1	1,453	3,203	YU235224	4BS20614-114	306	662	54	84	168	4.2	52	128	33	8	802	1815	3.3	
7426-3420	18GA\36"X144"	1	1,453	3,203	YU235224	4BS20614-115	306	662	54	84	168	4.2	52	128	33	8	802	1815	3.3	
28			39.285	86.499													58.499			
Remarks: NO MERCURY CONTAMINATION																				
Bend tested for all Heat NO.																				
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.																				

- PRIME MATERIAL, NO DINGS, NO DENTS, NO SCRATCHES
- P.O. NO. 497631 (VANCOUVER)
- SALES CONTRACT NUMBER: F05MB11
- DOCUMENTARY CREDIT NUMBER: ILCMP000165

YIEH MAU CORP.

Manager of Quality Assurance/Inspection

PO 442

AS
06/04/28